

Work Order ID 80169

80169

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February-13-12 10:38:39 AM

Item ID: D3296-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Assembly
 Start Date: 13/02/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 27/02/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/02/13 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3296	Rev A

100 Small Fab 0.00
100
 Small Fab Memo 0.00
 Small Fab Fabricate & assemble as per Dwg D3296.
 Transfer drill using DT8470 & DT9521

12/02/17 (6)

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00
 Quality Control

(46)

120 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 0.00
120
 Powdercoat Memo 0.00
 Powder Coating START TIME: 8:15 OVEN TEMPERATURE:
 FINISH TIME: 8:45

6X4 M-L 12/02/29

M 115128

3200F

8:45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3296-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Assembly

Start Date: 13/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

Handwritten: 2 x 6 11 11 02/29

140

Small Fab

0.00

140

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

Handwritten signature and date: 12/03/01

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

Handwritten: 12/03/01

Handwritten circled mark

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Item ID: D3296-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Door Assembly

Start Date: 13/02/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: ST218

0.00

160

Packaging

Memo

0.00

Packaging

(6x) SP 12-03-02

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MCJ 12/03/0212-03-2
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80169

80169

Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 *D3161-7* Hinge 14.0"		Manufactured	No			100	Each	1.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST031		1							
				76938		1							
D3161-9 *D3161-9* Hinge 17.0"		Manufactured	No			100	Each	0.0000	1	6			
								B 79305 (6x)	**				
D3296-1 *D3296-1* Door Panel		Manufactured	No			100	Each	12.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST233		12							
				75064		12							
D3296-3 *D3296-3* Door Panel		Manufactured	No			100	Each	16.0000	1	6			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST233		16							
				75061		16							

EP 12/02/17
B 79304 (6x)

EP 12/02/17
B 79305 (6x)

EP 12/02/17

6

EP 12/02/17

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Work Order ID: 80169

80169

Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-6

Purchased

No

100

Each

2,595.000

1

6

MS20470AD4-6

Rivet, Universal Head

**

EP 12/03/01

Location

Loc Qty

Loc Code

ST319

2595

117395

16

118927

392

119109

14

119546

685

120142

1488

6

D2137

Manufactured

No

140

Each

28.0000

1

6

D2137

Decal - No Step

**

EP 12/03/01

Location

Loc Qty

Loc Code

GA

28

76064

8

79837

20

6

D2419

Manufactured

No

140

Each

2.0000

1

6

D2419

Handle

**

EP 12/03/01

Location

Loc Qty

Loc Code

GA

2

78994

2

2

B 80809 (4K)

D2462

Manufactured

No

140

f

358.8002

0.3333

1.9998

D2462

Seal

**

EP 12/03/01

Location

Loc Qty

Loc Code

ST404

358.8002

48530

358.8002

1.9998

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 80169

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Parent Item: D3296-041

D3296-041

Parent Item Name: Door Assembly

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 6.00

Required Qty: 6.00

D2728-1 Manufactured No

140

Each

0.0000

0

0

D2728-1

**

Dart Logo label

MS20470AD4-4

Purchased No

140

Each

6,598.000

25

150

MS20470AD4-4

**

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

6598

116188

136

116391

66

118614

1190

119109

348

120361

1858

120518

3000

NAS1149DN632J

Purchased No

140

Each

446.0000

1

6

NAS1149DN632.J

**

Washer

Location

Loc Qty

Loc Code

ST298

446

118428

446

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

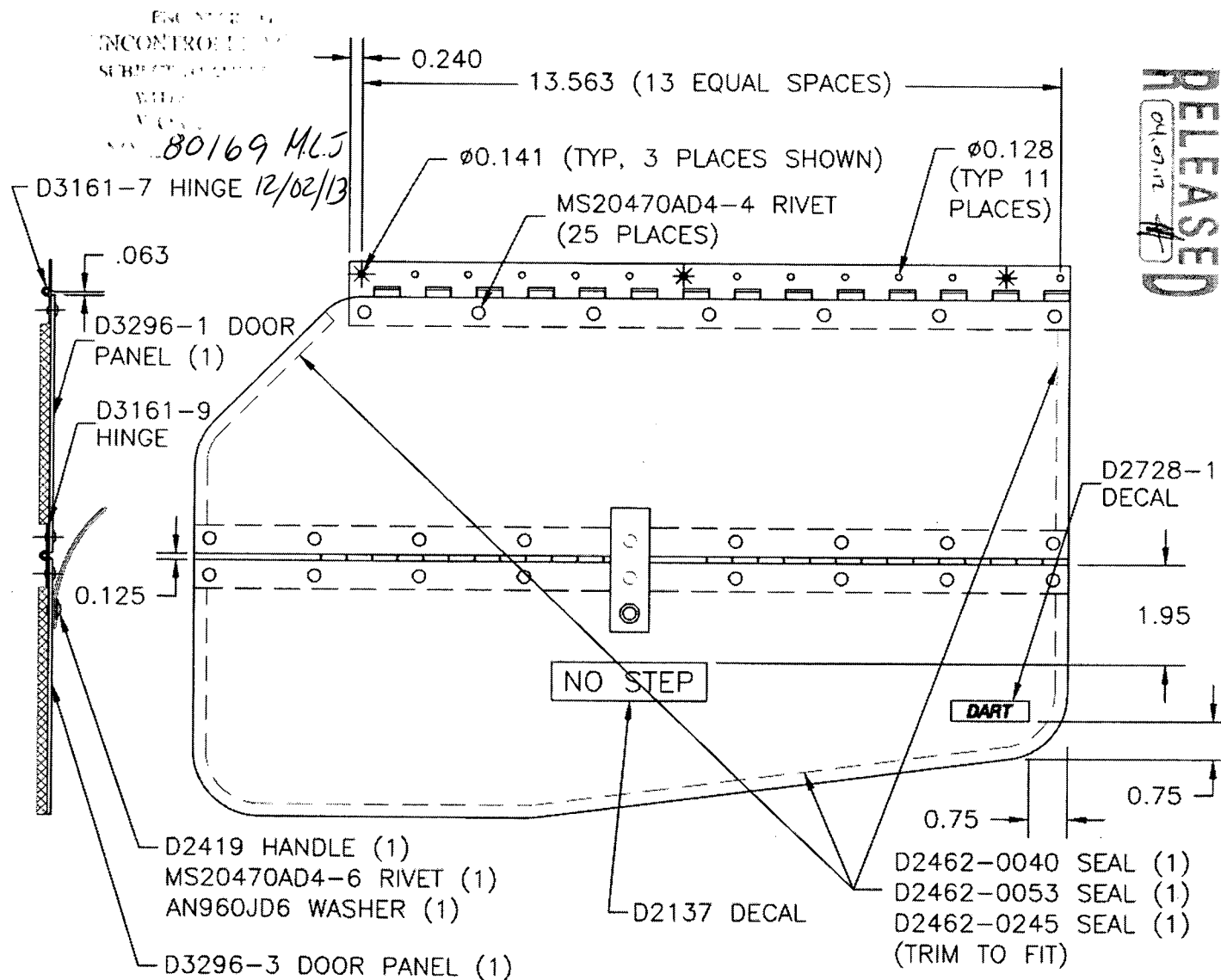
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3296	1 OF 2
04.06.28		TITLE	SCALE
		DOOR ASSEMBLY	1:3
A	04.06.28	NEW ISSUE	

RELEASED
04.07.12



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

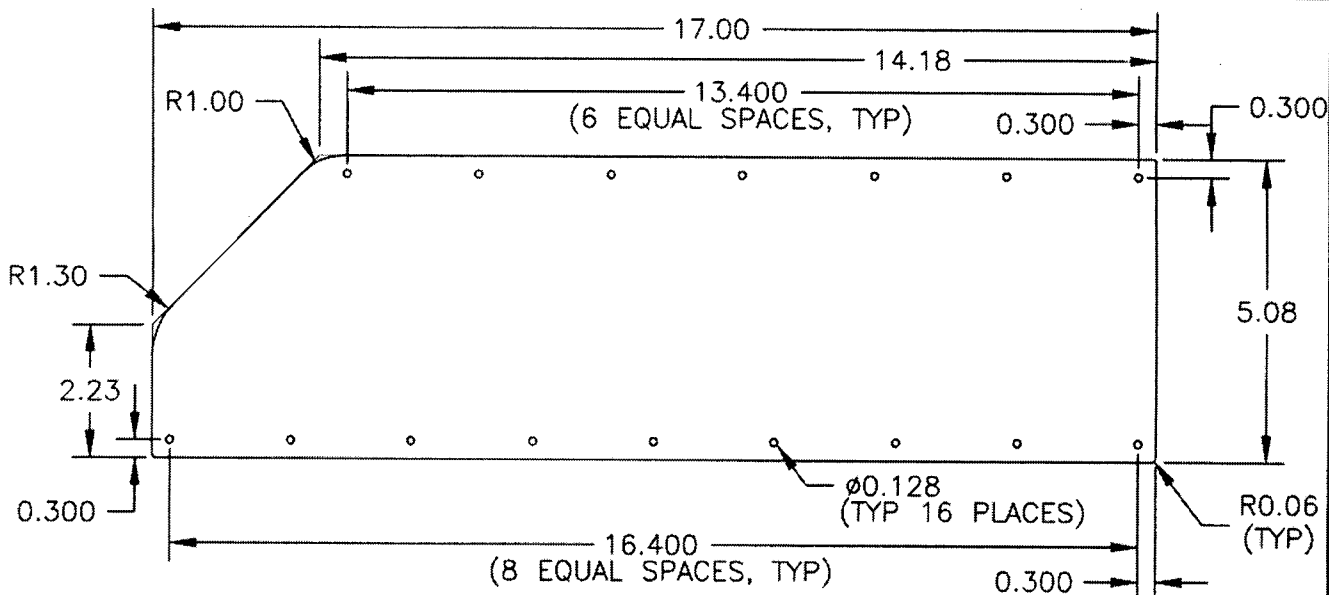
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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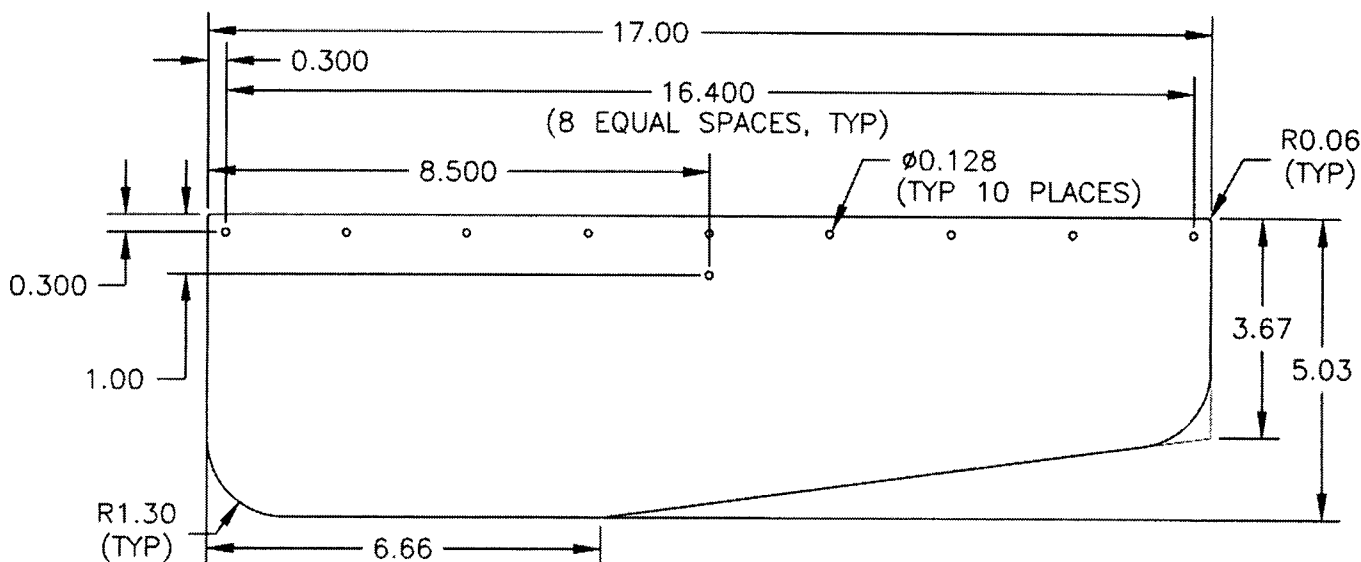
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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